

Date: Wednesday, 2/20/2008 4:20:31 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SPACERS (1/4 THICK)
Job Number : 37521	
Estimate Number : 10247	
P.O. Number :	Part Number : D2022101
This Issue : 2/20/2008 S.O. No. :	Drawing Number : D2022 REV. --
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : --
Previous Run : 33985	Material :
Written By :	Due Date : 3/20/2008 Qty: 160 Um: Each
Checked & Approved By : <u>JF 08/02/21</u>	
Comment : Est D 02.03.07 Now made in house NG	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6R0750	6061-T6 Round Bar .750"
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Comment: Qty.: 0.0329 f(s)/Unit Total : 5.2584 f(s)
 6061T6 Round Bar .750"
 Material: 6061-T6 (QQ-A-225/8)x.750Ø bar
 (M6061T6R0.750 Batch: M103857

J.F. 08/02/23 (180)

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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Comment: HARDINGE CNC LATHE SMALL
 1- Note: .257(F) Dia drill
 2-Turn Blank as per FolioFA206
 3-Tumble & deburr any sharp edges as per dwg

J.F. 08/02/23 (180)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 08/02/23 (180)

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

J.F. 08/02/24

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
 Identify and Stock
 Location: 5T9

AS 08/02/25 (180)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: PD Date: 08/02/25
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACERS (1/4 THICK)

Job Number: 37521

Part Number: D2022101

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



(180)

Comment: FINAL INSPECTION/W/O RELEASE

2008/2/25

Job Completion



mi 2008/2/25 (180)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

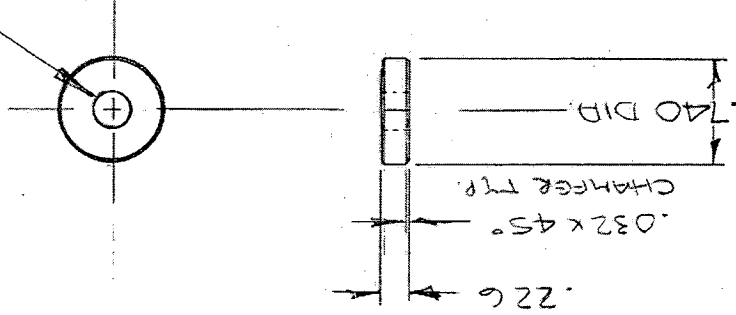
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

RELEASED
770119 86J



DRILL F (.257) DIA IN -101
DRILL P (.323) DIA IN -103

D2022-101
D2022-103

MAT'L: ALUMINUM 6061-T6 (60-A-225/B)

PART NO.	ITEM	DESCRIPTION	MATERIAL	SPEC/VENDOR
D2022-103	SPACER 5/16	ALUM 6061-T6	60-A-250/B	
D2022-101	SPACER 1/4	ALUM 6061-T6	60-A-250/B	

REVISION	APPROVED	DESCRIPTION	CHANGE
REPORT ALL DISCREPANCIES - DO NOT SCALE			
1. DIMENSIONS ARE IN INCHES 2. DIMENSIONS SHOWN EXCEPT AS NOTED 3. DIMENSIONS SHOWN EXCEPT AS NOTED 4. DIMENSIONS SHOWN EXCEPT AS NOTED 5. DIMENSIONS SHOWN EXCEPT AS NOTED 6. DIMENSIONS SHOWN EXCEPT AS NOTED 7. DIMENSIONS SHOWN EXCEPT AS NOTED 8. DIMENSIONS SHOWN EXCEPT AS NOTED 9. DIMENSIONS SHOWN EXCEPT AS NOTED 10. DIMENSIONS SHOWN EXCEPT AS NOTED			
BASIC CODES			
D-COMPL D-COMPL D-COMPL D-COMPL D-COMPL D-COMPL D-COMPL D-COMPL D-COMPL D-COMPL			
APPROVAL			
DART AERO ACCESSORIES INC			
SPACERS			
D2022			

NO. 37521
WORK ORDER
SUBJECT TO APPROVAL
UNCOMMON IN THE
ENGINEERING
RETURN TO
SHOP COPY



22022